

Date: Wednesday, 21/01/2009 12:51:05 PM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SWING ARM
Job Number : 45018	
Estimate Number : 11303	
P.O. Number :	Part Number : D34479
This Issue : 21/01/2009 S.O. No. :	Drawing Number : D3447
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 41352	Material :
Written By :	Due Date : 28/01/2009 Qty: 10 Um: Each
Checked & Approved By : <u>mf 09-01-21</u>	
Comment : Est A 05.08.26 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M7075T6B1500X1500	7075 T6 BAR 1.500 x 1.500
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Comment: Qty.: 0.7350 f(s)/Unit Total : 7.3500 f(s)

7075 T6 BAR

Material: 7075-T6 Bar (QQ-A-200/8 or QQ-A-225/8)

(M7075T6B1.500x01.500)

Identify for D3447-9

Batch: M106368 x8

⑧

JL 09/01/26

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks: 1.500" x 1.500" x 8.400" long

⑧

JL 09/01/26

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA544 and Dwg B67-43001

Identify as D3447-9 Dwg Rev A Folio Rev AA

Deburr

⑧

mf 09/01/27

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

⑧

mf 09/01/27

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

⑧

mf 09/01/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SWING ARM

Job Number: 45018

Part Number: D34479

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HL

09-01-28

X8

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

Mask inside holes as per Dwg D3447 prior to painting

M102316.

START TIME:

10:30

OVEN TEMPERATURE:

320°

FINISH TIME:

11:00

MD / PR

09-02-05

(8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FX

09/02/05

(8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Pc 9/2/05 (8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/09 HJ

Job Completion



C 09/02/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PART AEROSPACE LTD		Work Order:	45 018
Description: SUING ARM		Part Number:	D3447-9
Inspection Dwg: D3447 Rev: A			Page 1 of 1

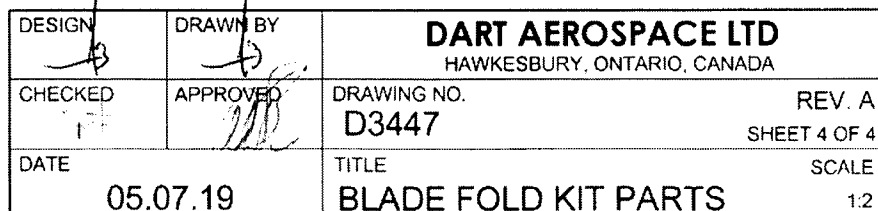
FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**[illegible]

Measured by:	<i>mmf</i>	Audited by:	<i>ml</i>	Prototype Approval:	N/A
Date:	09/01/27	Date:	09/01/28	Date:	N/A

ev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





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